

Date: Tuesday, 1/16/2007 11:36:12 AM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: DUAL HIGH BACK SEAT
Job Number	: 30295		
Estimate Number	: 12271		
P.O. Number	: <u>N/A</u>	Part Number	: D350689041
This Issue	: 1/16/2007 S.O. No. : <u>N/A</u>	Drawing Number	: IIN-D350-689 PG9
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: <u>N/A</u> Type : LARGE FAB ASSY	Drawing Revision	: A
Previous Run	: 30239	Material	: <u>N/A</u>
Written By	: <u>[Signature]</u>	Due Date	: 2/15/2007
Checked & Approved By	: <u>[Signature] 07.01.16</u>	Qty:	1 Um: Each
Comment	: Est Rev: H Removed Sub-Parts 06-02-09 JLM Est Rev: L As per NCR 070 06-09-06 JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D30231	Back Panel
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number	Description	Batch
1 D3023-1	Back Panel	<u>B30304</u>

2.0	D3017041	Back Frame Assembly
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number	Description	Batch
1 D3017-041	Back Assembly	<u>B30303</u>

3.0	MS20600AD4W2	Rivet
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Comment: Qty.: 40.0000 Each(s)/Unit Total : 40.0000 Each(s)

Pick:

Qty Part Number	Description	Batch
40 ms20600ad4w2	Rivet	<u>M4747</u>

4.0	MS20600AD4W3	Cherry Rivets
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Comment: Qty.: 6.0000 Each(s)/Unit Total : 6.0000 Each(s)

Cherry Rivets

Batch: M104715

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: DUAL HIGH BACK SEAT

Job Number: 30295

Part Number: D350689041

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Assemble as per IIN 350-689-041

ml 07/08/28 xl

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

En 07/08/28 (41)

7.0

POWDER COATING

POWDER COATING



M104846



(IX)

Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

m-p 07/08/28

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

ml 07/08/28

9.0

D30241

Spacer



Comment: Qty.: 3.0000 Each(s)/Unit Total : 3.0000 Each(s)

Pick:

Qty Part Number Description Batch

3 D3024-1 Spacer *B24629*

CF

10.0

D30281

Stud



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part Number Description Batch

4 D3028-1 Stud *B24630*

CF

11.0

D30291

Spring



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 D3029-1 Spring *B33370*

CF

CF 07/08/28

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DUAL HIGH BACK SEAT

Job Number: 30295

Part Number: D350689041

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

D30301

Lock



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 D3030-1 Lock 624631-

13.0

D30311

Loop



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 D3031-1 Loop 633474-

14.0

AN312A

Bolt



Comment: Qty.: 3.0000 Each(s)/Unit Total : 3.0000 Each(s)

Pick:

Qty Part Number Description Batch

3 AN3-12A Bolt 1100188

15.0

AN960JD10L

Washer



Comment: Qty.: 23.0000 Each(s)/Unit Total : 23.0000 Each(s)

Pick:

Qty Part Number Description Batch

23 AN960JD10L Washer 1103044-

16.0

MS21042L3

Nut



Comment: Qty.: 23.0000 Each(s)/Unit Total : 23.0000 Each(s)

Pick:

Qty Part Number Description Batch

23 MS21042L3 Nut (or -3) 1104936-

17.0

MS24693S272

Screw



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part Number Description Batch

4 MS24693-S272 Screw 1104746-

CP 07/08/270

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 1/16/2007 11:36:13 AM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DUAL HIGH BACK SEAT

Job Number: 30295

Part Number: D350689041

Job Number:



Seq. #:

Machine Or Operation:

Description :

18.0

MS27039117

Screw



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part Number Description Batch

4 MS27039-1-17 Screw M11540

19.0

MS27039119

Screw



Comment: Qty.: 12.0000 Each(s)/Unit Total : 12.0000 Each(s)

Pick:

Qty Part Number Description Batch

12 MS27039-1-19 Screw M10089

20.0

D30221

Seat Pan



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D3022-1 Seat Pan B25796

21.0

D3021041

Tube Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D3021-041 Tube Assembly B25961

22.0

D3016041

Seat Frame Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D3016-041 Frame Assembly B25789

23.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Assemble as per Dwg IIN-D350-689

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 07/08/21
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 1/16/2007 11:36:13 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DUAL HIGH BACK SEAT

Job Number: 30295

Part Number: D350689041

Job Number:



Seq. #:

Machine Or Operation:

Description :

24.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

07/08/28

25.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

07/14/28

26.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07/08/29

Job Completion



07/08/29

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

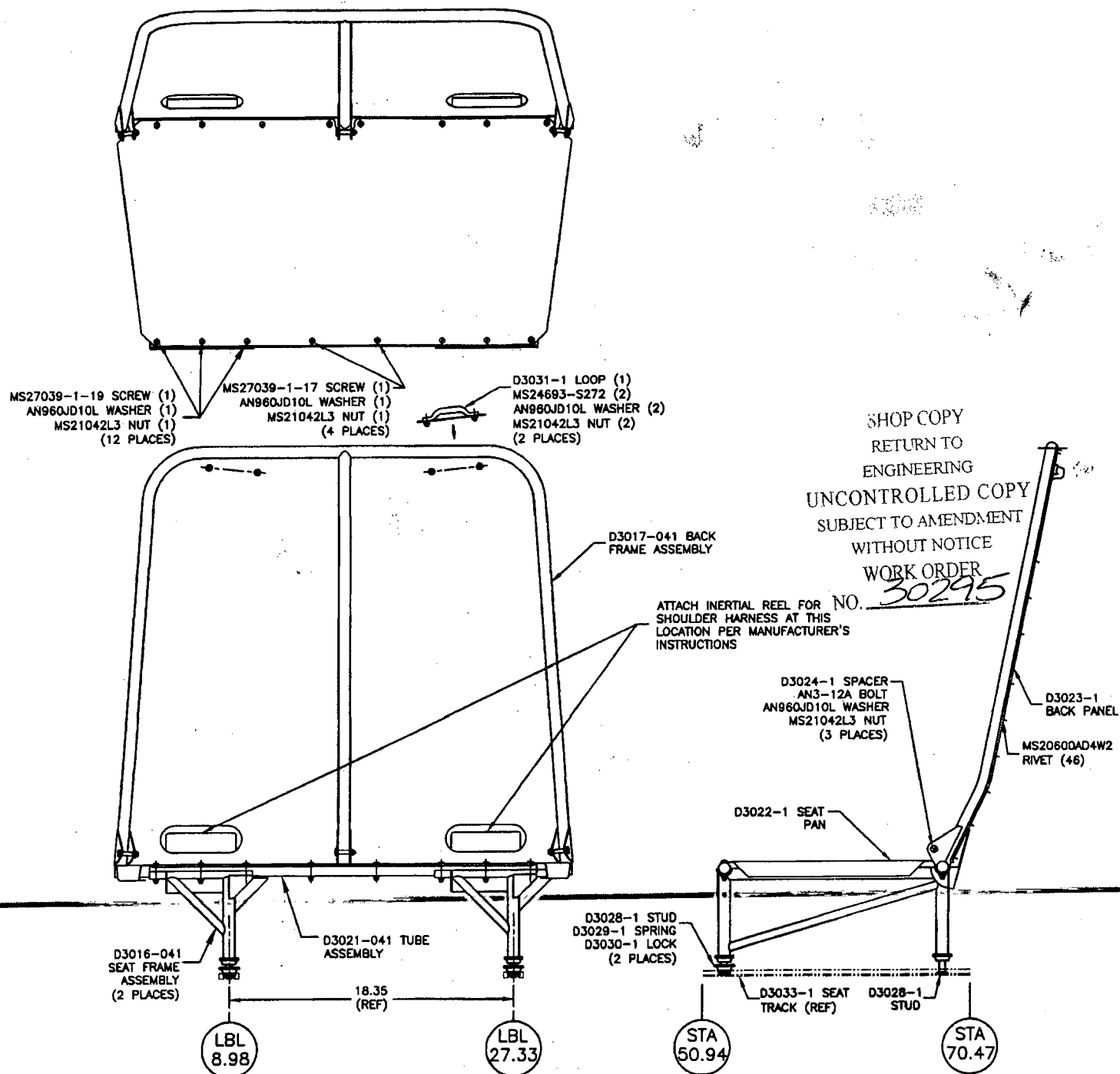


FIGURE 6: Installation of D350-689-041 Dual High Back Seat Assembly

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Revision: A

Date: 01.05.30

DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>HA</i>	APPROVED <i>HA</i>	DRAWING NO. DSI 9349	REV. A SHEET 1 OF 1
DATE 06.08.16		TITLE RIVET CHANGE	SCALE NTS
A	06.08.16	NEW ISSUE	

DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS IIN-D350-689 Rev.A
AND INSTRUCTIONS FOR CONTINUED AIRWORTHINESS ICA-D350-689 Rev.0
REF. CANADIAN STC: SH02-33
REF. FAA STC: SR01620NY

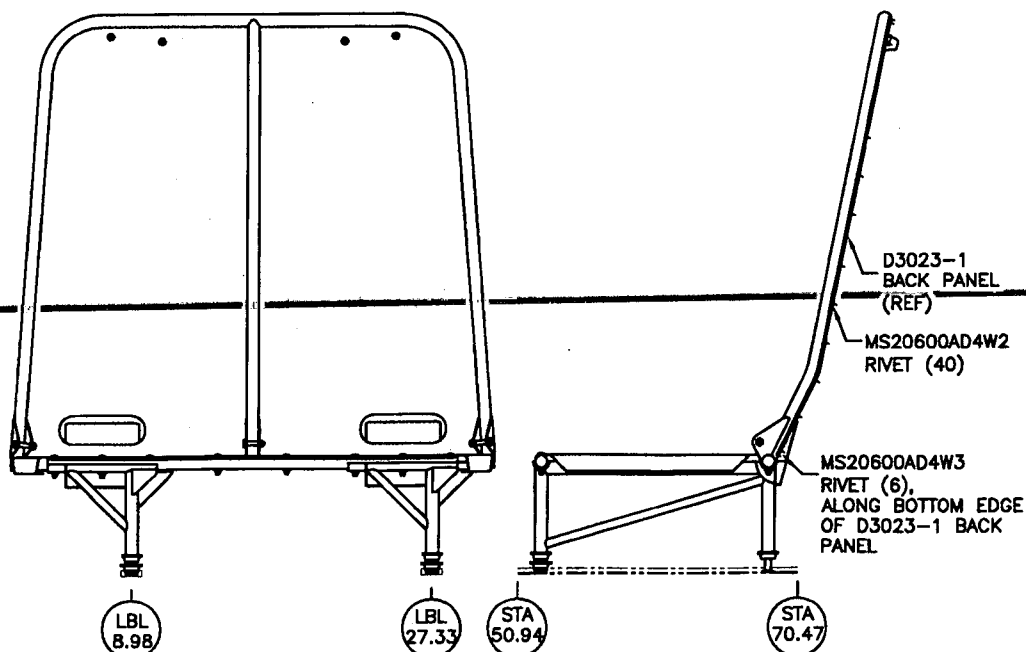
Some rivet lengths have changed, as indicated below, to ensure proper assembly of the D350-689-041 Dual High Back Seat Assembly. If installing replacement parts, it is acceptable to use longer rivets in other locations as required to ensure proper fastening. The parts list is revised as follows:

WAS:

QTY -041	Part Number	Description
X	D350-689-041	DUAL HIGH BACK SEAT ASSEMBLY
46	MS20600AD4W2	RIVET

NOW:

QTY -041	Part Number	Description
X	D350-689-041	DUAL HIGH BACK SEAT ASSEMBLY
40	MS20600AD4W2	RIVET
6	MS20600AD4W3	RIVET



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
30295

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED
[Signature]
BY: *[Signature]*
D. SHEPHERD (DE # 02)

DATE: 06.08.16
CERT. NO.: SH02-33
ISSUE NO.: 1

D350-689-041 Dual High Back Seat Assembly

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